E1

Web

October 14, 2009 11:09:10 AM

Item ID: **Revision ID:** D2654-7

Accept

Setup Start

Stop



Item Name:

Start Date: 10/14/2009 **Required Date:** 10/14/2009 Start Qty: 2.00

Req'd Qty: 2.00

Date: ______

Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan: MF

Date: 09-10-14 Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID **Operation** Description

Set Up/ **Run Hours** Draw Number Draw Rev.

Date:

Plan Accept Code Qty

Reject Qty

Reject Number

Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

Skidtubes

Memo

0.00

0.00

Skidtubes Skidtubes

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654 \$\square\$ 3-Using the uni-bit, open holes to finish

110

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

HandFinish

120

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

Dart	Aerospace I	_td

	-							
W/O:			WO	RK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	ı:	QA: N/C Clo	sed:	Date: _	···
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		-
DATE	STED	Description of NC Corrective Action			n B	Verification	Approval	. Approval
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 52801

October 14, 2009 11:09:10 AM



Page 2

Item ID:

D2654-7

Accept

Setup Start

Revision ID: Item Name:

E1 Web

Cust Item ID:

Start Date:

10/14/2009 **Required Date: 10/14/2009** Start Qty: 2.00 **Req'd Qty: 2.00**

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Start Stop

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Plan

Code

Reject Accept Qty

Qty

Run

Reject Number

Stamp

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

Draw

Number

140

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09-10-14

Dart Aerospace Ltd

W/O:		WORK ORDER	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	• ·	PAR #: Fault Category:	NCR: Yes	No DO	۸٠	Date:						

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	_ Date:

NCR: WORK ORDER NON-CO					NFURMANUE (NCH)					
		Description of NC		Corrective Action Section B			Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector		
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Picklist Print

October 14, 2009 11:09:09 AM

Work Order ID: 52801

Parent Item: D2654-7RevE1

Parent Item Name: Web

Start Date: 10/14/2009

Required Date: 10/14/2009

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-7-140RevD1		Manufactured	No			100	Each	74.0000	2.0000			

EXT. "I BEAM" THICK

Comments:

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		
ST	74	
41591	74	

Aum 9-10-14 (2)

Dart Aerospace Ltd

W/O:	·		WC	RK ORDER CHANG	BES .		to		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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- And									
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DO	QA:	Date:	
	R	esolution:	Disposition	n:	QA: N/C	Closed: _		Date: _	·
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			11.000
DATE	STEP	Description of NC Corrective Action			Section B Veri			Approval	Approval
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97.10.29

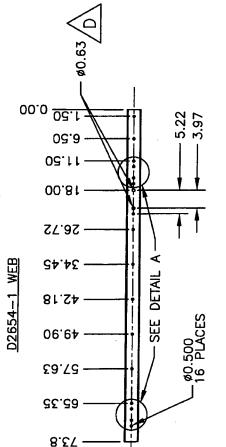
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	DATE			TITLE	SCALE
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	A		97.03.25	NEW ISSU	JE

ALTER HOLE PATRN., 0.500 WAS 0.438

CHANGED HOLE PATTERN

GHW HOLES CHANGED TO Ø0.63



	04.05	.26	CHANG	SE LEN	IGTHS,	REFORMA	ıΤ
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		00.7	<u> 49 — </u>	łК	<u>Σ</u>		

00.77

ट.08 8,08 MAKE FROM D2600—5—108 EXTRUSION FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5.000

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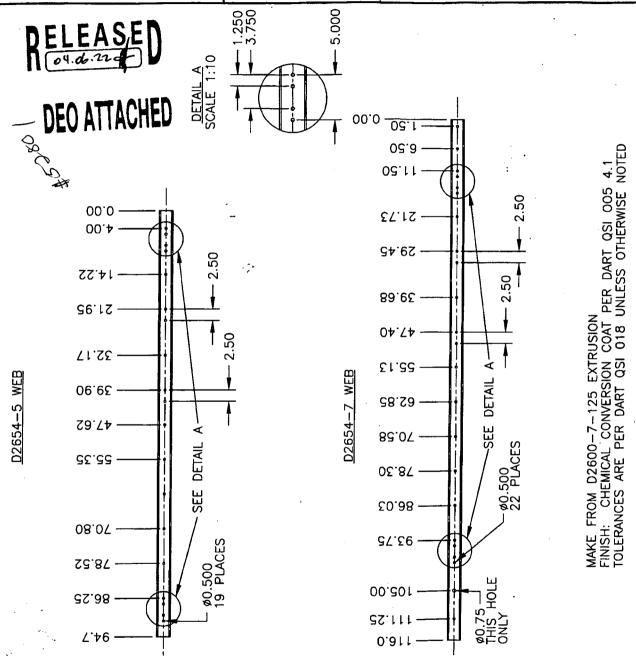
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Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORE	DER NON-CONFORMANC	E (NCR)			
		Description of NC	Description of NC Corrective Action Section B			Verification	Annual	A
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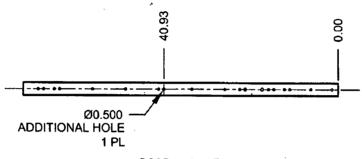
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		Description of NC		Corrective Action Section		Ver	ification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da	1& _S	ection C	Chief Eng	QC Inspector
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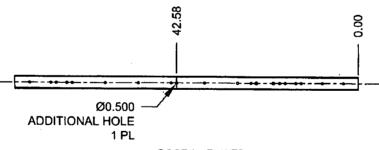
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DRAWN	_ (P		CHECKED	P#	MFG. APPR.	E	APPROVED IN		DE APPR.	
DATE	09.03.	.11	DATE	09.03.11	DATE	09.04.03	DATE 19.04.03	>	DATE 09.04.03	

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:





D2654-1 WEB



D2654-3 WEB

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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